

# Work Order ID 59975

Tuesday, June 22, 2010 10:15:13 AM

Page 1

Item ID: D206-667-103

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Fwd

Start Date: 6/22/2010 Start Qty: 1.00

Required Date: 7/20/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-6-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D206-667-143

Rev C

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-103 CHG004

Solosh

10/07/21

110

0.00



Packaging

Pick Kit

Packaging

Memo

0.00

Packaging

IX 10-06-28

120

0.00



CNC Bend 2

BENDING MACHINE - CROSSTUBES

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D206-667-143 using CNC bender program

IX 10-06-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC15- Crosstube Dimensional Check

0.00



QC

Memo

0.00

6/10/2010



Quality Control

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  Crosstubes	Crosstubes	0.00							
Crosstubes	<b>Memo</b> 1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill all (3) top holes.  3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.  4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-143. Drill only the top (2) holes.  5-Drill pilot holes as per Dwg D206-667-143. Drill only the top (2) holes.  6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.  7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.  8-C'sink holes as per Dwg D206-667-143. Allow rivet to sit below surface to compensate for paint.  9 -Scribe part # and batch # using vibrating stylus as per Dwg D206-667-143 Inside of Cuff(Donot engrave on outside of tube)  10-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-143	0.00							

MP 10-06-29

-AWM 10-06-29

W/O:		WORK ORDER CHANGES						
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150 Crosstubes Chemical Conversion 0.00



HandFXtube

Memo

0.00

Hand Finishing Crosstubes

1 - - AWM  
0-06-29

160 QC3- Inspect Part Finish 0.00



QC

Memo

0.00

Quality Control

8.06/20

170 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

8.06/30

②

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DCA: \_\_\_\_\_ Date: \_\_\_\_\_

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \_\_\_\_\_  
Stop \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Outsource process - NDT per QSI038 4.1 <i>P/O: 12200</i>	0.00							
Outsource2	Memo	0.00							
Outsource process - NDT	CROSSTUBES <i>P/O: 12212</i>								
190 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Ensure copy of NDT results attached to work order.								
200 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*CY 10/7/11 (1)**CY 10/7/11 (1)**P/O 10/7/11 (1)*  
*P/O 10/7/11 (1)**BT 10-07-14*

W/O:		WORK ORDER CHANGES						
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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210



SprayPaint

0.00

SprayPaint

Memo

0.00

Spray Painting

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 9:00

Finish Time: 10:00

PAINT:

Start Time: 2:00

Finish Time: 3:00

8T 10-07-14

220



QC14- Inspect Spray Paint

0.00

QC

Memo

0.00

Quality Control

Wrap in plastic bag to protect from scratches

MM 10 07-15 17

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DCA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Cust Item ID:**

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**Stop**

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

230

0.00



## Crosstubes

0.00

## Crosstubes

## Crosstubes

## Memo

(ASSEMBLE AS PER DWG D206-667-143)

1-Install support using 0.03" to 0.06" thick layer of magnobond 6398 per QSI 015. Let cure for 12h after installation and prior to packaging. Note: (2) Aft holes should be facing up.

A/R Magnobond 6398: 114 158

2-Install supports and clamps as per Dwg D206-667-143. Torque clamps to 80-100 in lb

3-Install nut plates as per Dwg D206-667-143. Touch-up rivet heads with Imron paint. *→ 1001 1001 1001*

240

QC5- Inspect part completeness to step on W/O

0.00

0.00

[illegible]

QC

## Quality Control

## Memo

W/O:		WORK ORDER CHANGES						
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop



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Reference:

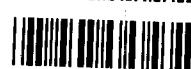
Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

6/10/12/21 (U)

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

8/10/12/21

(U)

270



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-667-103

Location:

PPP Rev: D

6/10/12/21 (U)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/22

10-7-21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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# Picklist Print

Tuesday, June 22, 2010 10:15:17 AM

Page 1

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Parent Item: D206-667-103

Parent Item Name: Crosstube Fwd

Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM  
 IPP Rev:G 08-06-03 update as per DSI9415 (ECN1198) DD verified by:  
 IPP Rev:H 08.11.17 QC5 was QC6 at step 12 KJ verified by: EC  
 IPP Rev:I 08-12-15 add magnobond DD verified by:EC  
 IPP Rev J 09.01.06 ECN 08-562 EC verified by: DD  
 IPP Rev:K 09-01-19 as per DSI9439 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D206-667-103TRN

Manufactured No

110

Each

2.0000

1

1



Crosstube Turning DetailL

Location

Loc Qty

Loc Code

LG

2

55831

1

55832

1

D2873-043

Manufactured No

230

Each

48.0000

2

2



Nut Plate Assembly

Location

Loc Qty

Loc Code

LG

48

53966

20

56466

8

57337

20

D2873-045

Manufactured No

230

Each

44.0000

2

2



Nut Plate Assembly

Location

Loc Qty

Loc Code

LG

44

53967

5

53968

20

57336

19

MB 10-06-28

IX

ML 10.07.19

ML 10.07.19

W/O:		WORK ORDER CHANGES						
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Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 1.00

Required Qty: 1.00

D2891-1

Manufactured No

230

Each

77.0000

2

2



2.25 Support



85 10-07-15

## Location

## Loc Qty

## Loc Code

LG

77

43880

3

46159

20

50952

18

53347

4

53773

20

55786

12

x2

D3595-063-395

Manufactured No

230

Each

10.0000

4

4



RUBBER CUSHION



## Location

## Loc Qty

## Loc Code

FP

10

44667

10

RUBBER CUSHION .63" x 3.95" (4)

MS20601-AD4W8

Purchased No

230

Each

342.0000

14

14



RIVET



## Location

## Loc Qty

## Loc Code

ST322

342

108521

98

112203

244

my 10-07-19

P40

Tuesday, June 22, 2010 10:15:17 AM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O: 59975		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-07-15		used D 3695-063-530 + trim to size to replace D 3695-063-390 (no stock)  D 3695-063-530 <u>B 51776</u> <sup>x4</sup>	BT	10-07-15			S 10/07/20

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Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 1.00

Required Qty: 1.00

MS21920-20

Purchased

No

230

Each

101.0000

4

4



Clamp (per MIL-DTL-8783C)



BT 10-07-15

## Location

## Loc Qty

## Loc Code

LG

101

112624

24

112793

3

114687

50

114779

24

AN5-30A

Purchased

No

250

Each

112.0000

4

4



BOLT



## Location

## Loc Qty

## Loc Code

ST339

112

112933

37

114437

25

114941

50

AN5-32A

Purchased

No

250

Each

178.0000

4

4



Bolt



## Location

## Loc Qty

## Loc Code

ST340

178

113121

28

114056

100

114405

50

AN5-7A

Purchased

No

250

Each

206.0000

10

10



Bolt



## Location

## Loc Qty

## Loc Code

ST337

206

113149

200

113226

6

M113149 4x  
M113236 6x

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Shop Packet Print

Page 3

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, June 22, 2010 10:15:17 AM

Page 4

Work Order ID: 59975

Parent Item: D206-667-103

Parent Item Name: Crosstube Fwd



Start Date: 6/22/2010

Required Date: 7/20/2010

Start Qty: 1.00

Required Qty: 1.00

8 AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000

18 18

Washer

8 AN970-4 Purchased No

250 Each

93.0000

12 12

Washer

Location

Loc Qty

Loc Code

ST349

93

112991

93

250 Each

681.0000

4

MS21042L5

8 Nut Purchased No

Location

Loc Qty

Loc Code

ST139

500

114813

500

ST300

181

114449

181

M114742

M112991

M114813

*[Signature]*

6/22/21

Tuesday, June 22, 2010 10:15:17 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

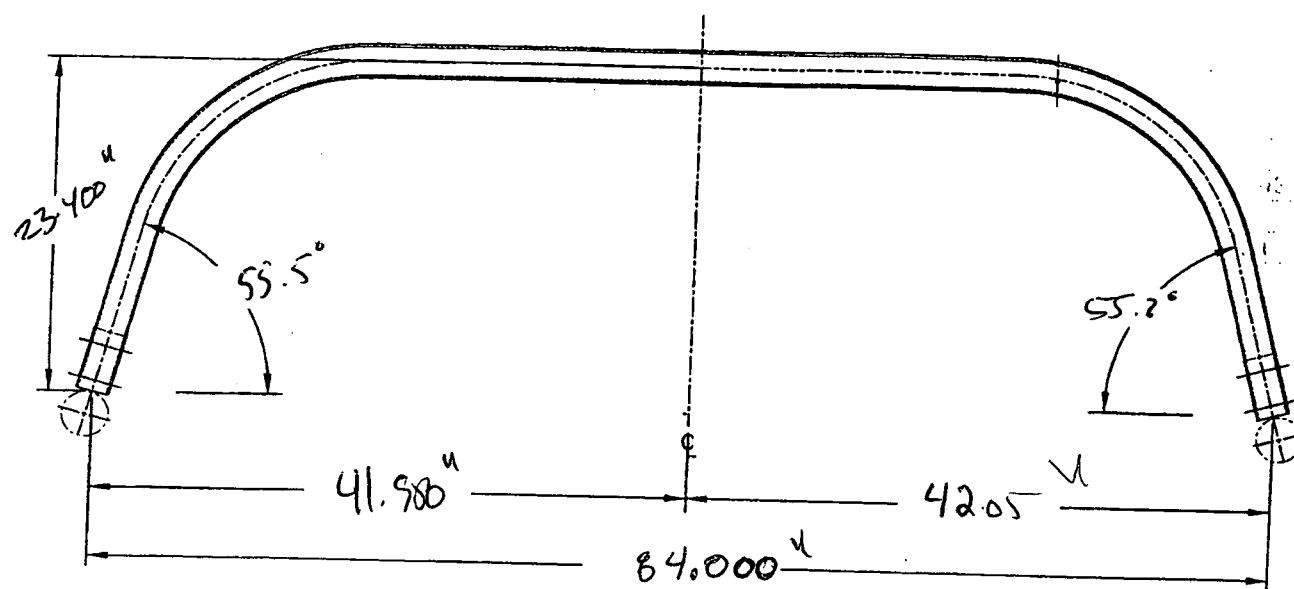
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	04978
Description: Crosstube High Fwd (206L)		Part Number:	D206-667-103
Inspection Dwg: D206-667-143	Rev: C	Page 1 of 1	

Required Dimension	Min	Max
Height	23.39	23.65
1/2 Span	41.79	42.05
Angle	54	56
Total Span	83.58	84.10



Comments

QC15 Inspection	6
Date	10/06/06

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.06.26	Dimensions updated per Dwg Rev C	KJ	
C	09.10.22	Minimum height dimension revised	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

# **GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURED FROM D6002-115  
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOT COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50925  
PS10-6-22

RELEASED

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF	DRAWING NO. D206-667-143 TITLE CROSSTUBE ASS'Y (206L HIGH FWD) SCALE NTS	
DATE	08.11.06	<small>COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

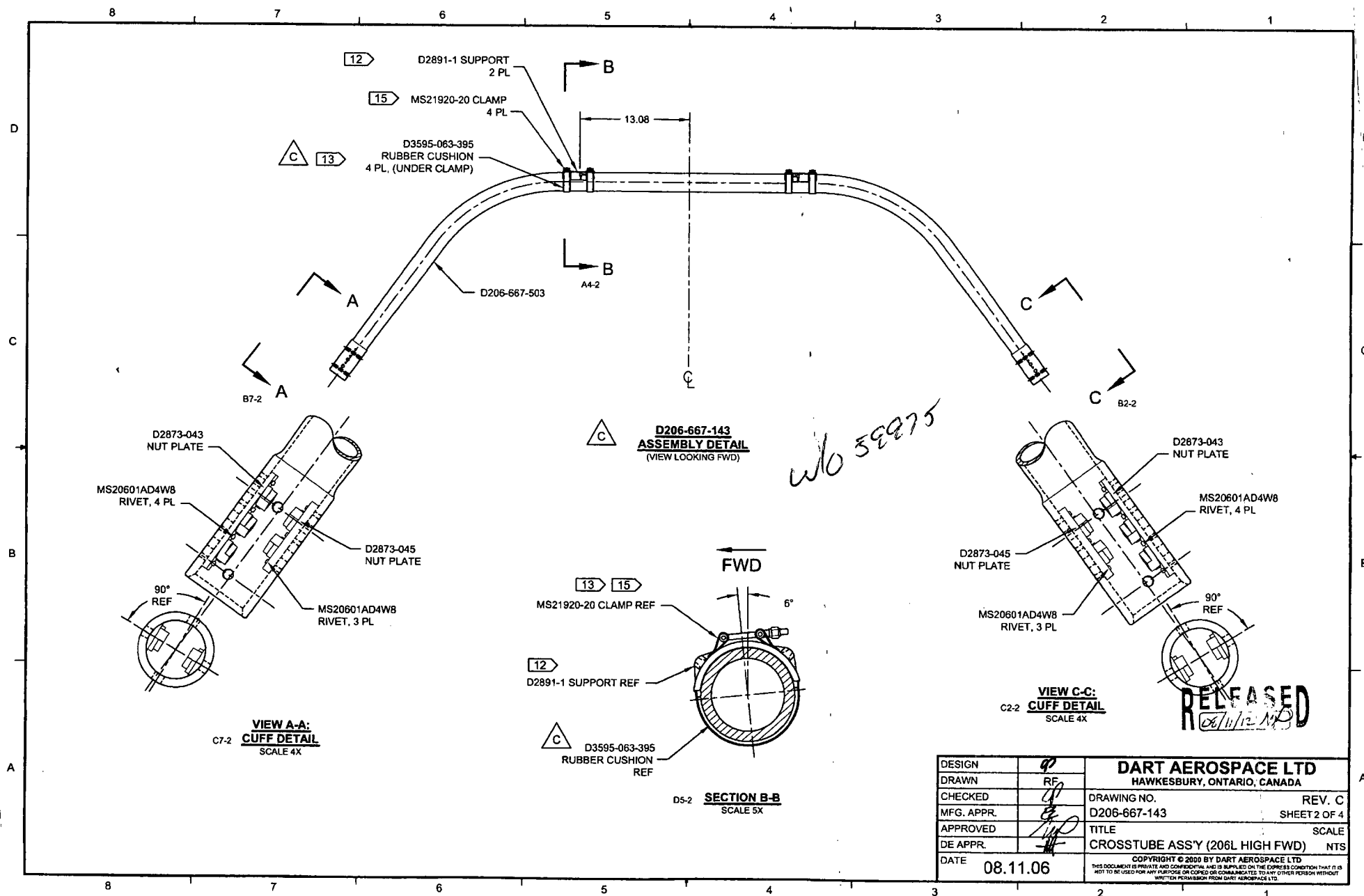
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN	9	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. C
MFG. APPR.	9	D206-667-143	SHEET 2 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

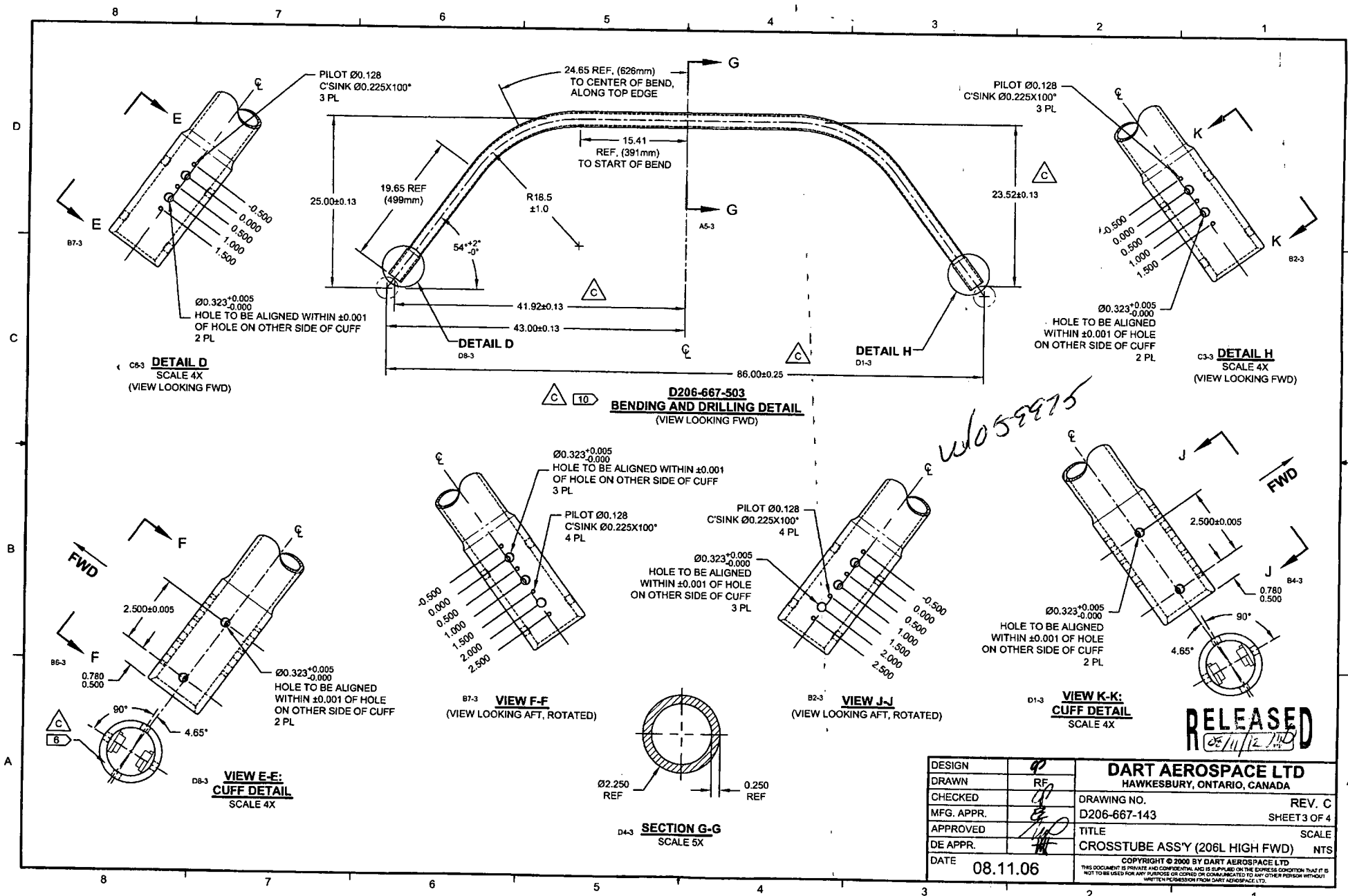
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





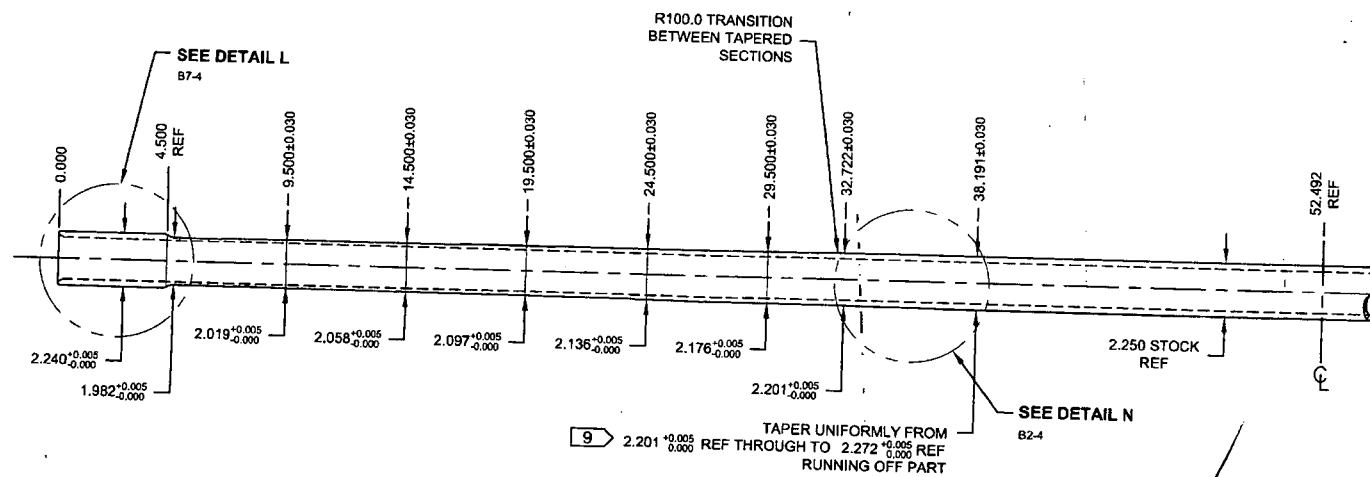
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

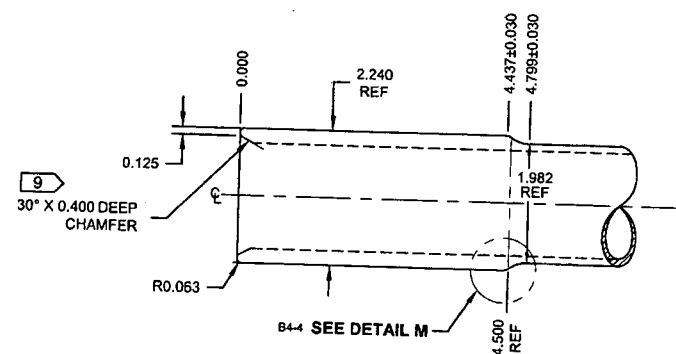
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

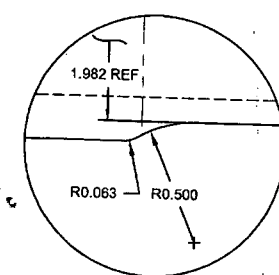
**NOTE:** Date & initial all entries



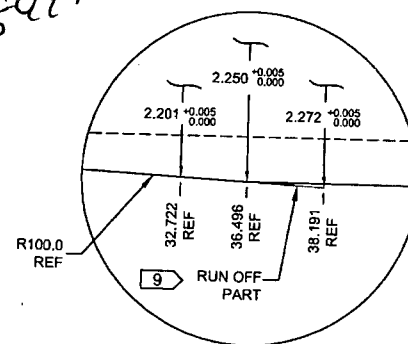
**TURNING DETAIL**



**DETAIL L:**  
CROSSTUBE CUFF  
NOT TO SCALE



**DETAIL M:**  
CUFF TRANSITION  
NOT TO SCALE



**DETAIL N:**  
TAPER RUN-OFF  
NOT TO SCALE

**RELEASED**

DESIGN	9	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. C
MFG. APPR.	9	D206-667-143	SHEET 4 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## LIQUID PENETRANT TEST REPORT

P- 15329

CLIENT	DART Aerospace	DATE	JUL 22 2010	PAGE	1	OF	1
ATTENTION	LINDA CHANTREL	ACUREN JOB No.	188-10-0776	TIME	AM	<input checked="" type="checkbox"/>	PM
ADDRESS	270 ABERDEEN ST. HAWKESBURY, ON. K6H 1K7	PO/VO No.		WORK LOCATION	MAIN SHOP - HAWKESBURY		
PROJECT	F.P.I. on CROSS TUBES & MACHINED PARTS	ACCEPTANCE STD.	ASTM 1417	REV./DATE	2007		
ITEM(S) EXAMINED	FOUR CROSS TUBES ELEVEN MACHINED STUDS.						

JOB DESCRIPTION	PROCEDURE No. LT-0002	REV./DATE	TECHNIQUE No. LT-2	REV./DATE
PART No.			MATERIAL	S. STEEL
SCOPE	WET FLOUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT 100% EXTERNAL.		THICKNESS	ALUMINE - ALUMINUM

TEST DETAILS	
METHOD	<input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE
FAMILY BRAND	MAGNAFLUX
PENETRANT	2LG7
PENETRANT REMOVER	H2O
DEVELOPER	SKD 52
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY
<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED	
BLACK LIGHT S/N 16454 <input type="checkbox"/> OUTPUT > 1000 $\mu$ W/cm <sup>2</sup> <input type="checkbox"/> AMBIENT < 2 fc	
LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE	
OTHER LABING	
LIGHT METER S/N 1098866 CAL DUE DATE OCT. 19 2010	

TEST SURFACE	
SURFACE CONDITION	<input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input checked="" type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/ 50°F <input checked="" type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F <input type="checkbox"/> > 52°C/ 125°F

RESULTS-	( <input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)
6 - STUDS - W.O. 59668 ✓	
5 - STUDS - W.O. 58635 ✓	
1 - CROSS TUBE - W.O. 59975 ✓	
1 - CROSS TUBE - W.O. 59976 ✓	
1 - CROSS TUBE - W.O. 58387 ✓	
1 - CROSS TUBE - W.O. 58388 ✓	
INDICATIONS ON CROSS TUBES W.O. # 59975 W.O. # 59976 W.O. # 58388 IN PROCESS TO BE REMOVED	

Scope of Services  
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care  
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	Jason Murdoch
TECHNICIAN (SIGNATURE):	Mike Johnston
NAME (PRINT):	Mike Johnston
CGSB LEVEL	1 <sup>ST</sup> TECHNICIAN
CGSB REG. No.	6606
CGSB LEVEL	2 <sup>ND</sup> TECHNICIAN
CGSB REG. No.	
DTR #	E63366
REPORT REVIEWED BY:	
NAME	INITIALS

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY



## LIQUID PENETRANT TEST REPORT

P- 15181

CLIENT DART Aerospace DATE Jul 14, 7-2010 PAGE 1 OF 1  
ATTENTION LINDA/CHANTEL ACUREN Job No. 108-10-0777 TIME AM ☒ PM ☐  
ADDRESS 1270 ABERDEEN, HAWKESBURY PO/WO No. —  
ONT WORK LOCATION MAIN SHOP - HAWKESBURY  
KOH 1K7 ACCEPTANCE STD. ASTM 1417 REV./DATE 2007  
PROJECT F.P.I. ON THREE CROSS TUBES THAT HAD PREVIOUS  
ITEM(S) EXAMINED INDICATIONS (SEE REPORT # 15329) & FOUR CROSS TUBES

JOB DESCRIPTION PROCEDURE No. LT0002 REV./DATE — TECHNIQUE No. LT-1417 REV./DATE —  
PART No. — MATERIAL STAINLESS STEEL THICKNESS ALUMINUM  
SCOPE WET FLUORESCENT LIQUID PENETRANT INSPECTION CARRIED OUT 100% EXTERNAL

## TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED  
FAMILY BRAND MAC NAPLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000  $\mu$ W/cm<sup>2</sup> ☐ AMBIENT < 2 fc  
PENETRANT 2L 67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE  
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER LABINO  
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE out 18 2010  
DEVELOPER TYPE ☐ NON AQUEOUS ☐ AQUEOUS ☐ DRY

## TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL  
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

1 - Crosstube W.O. 59975	✓
1 - Crosstube W.O. 59976	✓
1 - Crosstube W.O. 58388	✓
1 - Crosstube W.O. 60145	✓
1 - Crosstube W.O. 60146	✓
1 - Crosstube W.O. 59973	✓

NOTE: CROSS TUBES  
IT - W.O. 59975  
14 - W.O. 59976  
- W.O. 58388  
WERE ON REPORT # 15329.  
INDICATIONS WERE LOCATED  
- AREAS OF INTEREST WERE  
EXAMINED AT THIS TIME AND  
FOUND ACCEPTABLE.

## Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

## Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE <u>Ran Titley</u>	PRINT	SIGNATURE	DTR # <u>EG3368</u>
TECHNICIAN (SIGNATURE): <u>Mike Johnston</u>	1 <sup>st</sup> TECHNICIAN	2 <sup>nd</sup> TECHNICIAN	REPORT REVIEWED BY:
NAME (PRINT): <u>Mike Johnston</u>	CGSB LEVEL <u>2</u> SNT LEVEL <u>—</u>	CGSB LEVEL <u>—</u> SNT LEVEL <u>—</u>	NAME INITIALS
CGSB REG. No. <u>60606</u>		CGSB REG. No. <u>—</u>	